

Friday, 9/29/2006 10:38:49 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 28781		
Estimate Number	: 11545		
P.O. Number	: N/A	Part Number	: D204635011
This Issue	: 9/29/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 28780	Material	: N/A
Written By	: <u>                    </u>	Due Date	: 10/22/2006
Checked & Approved By	: <u>                    </u>	Qty:	1 Um: Each
Comment	: Est Rev:G 02.08.28 Removed QC5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

RS 021011

2.0	28781A	SKIDTUBE
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Comment: Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	B28781A

B06/11/23

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	B27998

B06/11/23

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

B06/11/23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28781

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: \_\_\_\_\_

PPP Rev: B

LB 06/11/23

⑦

✓ PB

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 06/11/23

Job Completion



C 06/11/23

**Dart Aerospace Ltd**

[illegible]

Part No: _____	PAR #: _____	Fault Category: _____	NCR: Yes No	DQA: _____	Date: _____
			QA: N/C Closed:		Date: _____

[illegible]

**NOTE:** Date & initial all entries

Date: Friday, 9/29/2006 10:39:30 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 28781A  
Estimate Number : 11546  
P.O. Number : N/A  
This Issue : 9/29/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : LANDING GEAR  
Previous Run : 28780A  
Drawing Name : SKIDTUBE  
Part Number : D204635041  
Drawing Number : D2590 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : N/A  
Due Date : 10/22/2006 Qty: 1 Um: Each  
Written By : 06 09 29  
Checked & Approved By : 06 09 29  
Comment : Est Rev: F 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25001190	Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B25858

DP 6-10-26

2.0	D2597	204 Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2597	204 Web	B28802

06/10/31

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2590 if necessary Deburr ends

3-Drill pilot holes using drill jig DT 8149 &amp; DT8711-1&amp;-2

4-Acid etch and Alodine tube per QSI 005 4.1

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid

6-Countersink holes as per Dwg D2590 without cutting fluid

7-Deburr and blow out all chips from inside of tube

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28781A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M102107 M-B 06/10/31

Sikaflex expire date: 07-02-01

Start Time: 10:30 AM

Fin Time: 2 PM 6-11-6

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

DP 6-11-6

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590

DP 6-11-7

2-Deburr ends after cutting. Remove alodine from around holes

M-B 06/11/09 D

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-11-09

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2576-3 Step B23060

BE 06-11-09

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number Description Batch  
17 D2579 Spacers B27921

BE 06-11-09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28781A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE M.2 06/11/09 ①

2-Weld step D2576 as per Dwg. D2590 and QSI 004

A/R

Aluminum Rod

M101655

BE 06/11/09

3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M101655

BE 06/11/09

4-Grind welds as per Dwg D2590 Grind flush ridge made from bending

Pm 06-11-13 ①

5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit crosstubes. Debur

Pm 06-11-13 ①

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Debur holes

Pm 06-11-13 ①

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Debur

Pm 06-11-13 ①

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

Pm 06-11-13 ①

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

06-11-14 ①

M06/11/14 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M102391

yl a.m 06/11/20 x1

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 11 23 ①

13.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Date: Friday, 9/29/2006 10:39:31 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28781A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1

D2577-1

Wearplate

526350

14.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	<u>528013</u>

15.0

D25777

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	<u>521607</u>

16.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	ALS7-1032-130	Inserts	<u>M18290</u>

17.0

AN960JD10L

Washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960JD10L	Inserts	<u>M102217</u>

18.0

AN34A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-4A	Bolt	<u>M18369 (17X)</u>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:39:31 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28781A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	D26364

20.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-3	Plug O-Ring	B27168

21.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

22.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

23.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M102660

Sikaflex expire date: 02/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

a.m 06-11/23 ①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 26/11/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:39:31 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 28781A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M102660

Sikaflex expire date: 02/07

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

M102635

Batch:

a.m 06/11/23 ①

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

FC 06 11 23 ①

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/23 ①  
U 06/11/23

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/11 DS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

# 00.08.28  
P 00.08.28

EFFECTIVE DEOS  
98/12/14

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 189.5 INCHES \*
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28781A



Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

[illegible]

DRILL PRIOR TO D2575 CAP  
INSTALLATION (2 PLACES)

#0.208

SEAL WITH  
SIKAFLEX-241

AN3-4A BOLT (1)

AN960JD10L WASHER (1)  
(2 PLACES)

D2575 CAP

UNC  
SUB

0.40

D2579 SPACER

WEB (REF)

-130 (REF)  
88 PLACES

AFTER PERFORM  
1. CHA  
2. INSE  
3. WEL  
4. C'BO

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO 0.437 X 1.00 DEEP

[illegible]

**D390U-041 ASSEMBLY DETAIL**

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5

1.5

1.5

1.5

1.5

1.5

P P P P

D

D

REFER TO DETAIL C

A13-4A BOLT (1)

A1960J10L WASHER (1)

(38 PLACES)

D2577-3

D2577-7

D2577-1

8

RE

Copyright 1996 by DART AEROSPACE LTD

NO. 73

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Barclay Elliott  
 Joint Welding Procedure TIG  
 Part number and Job number 204635041/B28780A

## TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS TIG  
 Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
 Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

## TEST RESULTS

Visual Pass ☒ Fail ☐  
 Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/01/08 Qualifier David David